

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,
REF. FAA STC SR02024SE

1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to add fwd ground handling holes to their D119-646-XXX skid tubes using the DSI 9594-011 Kit. One kit modifies 2 skid tubes.

2.0 PROCEDURE

Modify the skid tubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skid tube with \varnothing 0.500" (12.7 mm drill), and countersunk to \varnothing 0.650 x 100°, two places per side.
- 2.3 Deburr holes. Touch up affected area with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.4 Bond D2579 spacers into the \varnothing 0.500 holes center in the skid tube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.5 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.6 Repeat steps 2.1 to 2.5 for opposite skid tube.

3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER

4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9594	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
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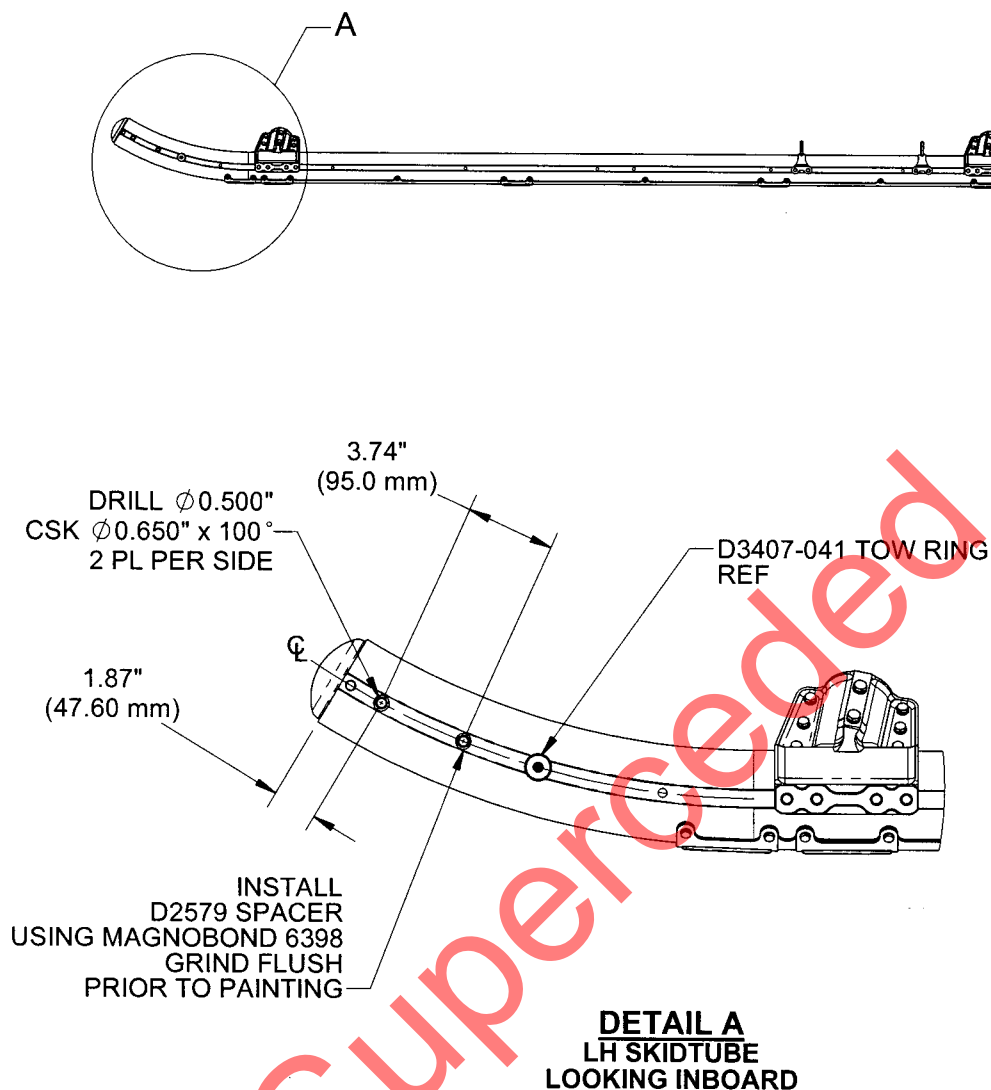


FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE

DESIGN	RF	DART AEROSPACE USA, INC KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9594	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
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